

# Tapered burr Ø2.3 Z25 with radius

**A11-011**

The tapered burr Ø2.3mm is ground from a solid carbide blank. The requested geometry of all 25 teeth is achieved with a 1V1 wheel.



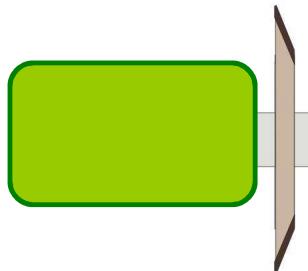
## 1. Cycletime for Production

Workpiece: Diameter 2.3 mm, Z 25, L14 mm, Helix angle 15° Material CARBIDE			
Operations	Probe	Flute 1	Flute 2
Feed [mm/Min]	2000	200	200
Power [kW]		3	2
Cutting speed [m/s]		32	32
Used wheels		1	1
Grinding time [s]	6	202	202
Total cycle time	6 Min 50		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

1	1V1 Ø60 D64
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## 3. Machine and Software Requirements

Machines: 5 axes CNC grinder : Aries5

Control: Fanuc 31i

Accessories:

Responsible engineer: SIW. 05.13

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